

Work Order ID 80265

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Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Assembly, LH

Start Date: 15/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/16 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3562	Rev E

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab 1-Cut D2622 extrusion as per Dwg D3562
 2-Deburr and bevel ends for welding

Ac 12.03.15 (X4)

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

LY 12.03.15 (4x)

120 Chemical Conversion Coat per QSI005 4.1 0.00
120
 HandFinish Memo 0.00
 Hand Finishing

12.03.16 4 /

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		SB 12/03/16		(4)			
140 *140* Small Fab Small Fab	Small Fab Memo 1- Transfer drill Rivet holes as per dwg D3562. 2-Touch-up rivet holes with alodine as per dwg d3562 3-Rivet legs using Magnabond as per dwg D3562. *****Ensure to wipe off any excess magnabond ***** A/R Magnabond 6398 Batch: 120666	0.00 0.00		12-03-16		4	0		
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							12-03-19 (4)

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab Large Fab	Large Fab Memo 1-Weld end caps as per Dwg d3562 & QSI 004. Inspect for foreign objects as per QSI 024. A/RAluminum Rod <u>119785</u> 2-Grind end cap welds flush as per Dwg D3562	0.00 0.00				4	0		
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00							8/12/13/24
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			8/12/13/24

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-041 PAR #: _____ Fault Category: Finish NCR: Yes No DQA 12/04/09 Date: 12/11/10

Resolution: Rework Disposition: Rework QA: N/C Closed Date: 12/11/10

NCR: 12138		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/12	2	Magnabond came through the p/c. R.C. Process.	12/03/12	→ Scuff at x2 steps completely with 370 grit paper.	12/03/12	12/02/12	12/03/12	12/03/12
			12/03/12	wash area with thinner.	12/03/12		12/03/12	12/03/12
				Re p/c as per assw. Start 10h45 temp 320°F Fin 11h15	12/03/12	12/02/12	12/03/12	12/03/12
				temp				

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	QC3- Inspect Part Finish	0.00							
220									
QC	Memo	0.00							
Quality Control									
230	Identify as per dwg & Stock Location	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

CHM d M 2/03/22

EP 2/04/02 (40)

12/4/12 J

012-041-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80265

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Parent Item: D3562-041

D3562-041

Parent Item Name: Step Assembly, LH

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec
 IPP Rev:D 08-07-28 add chemical conversion coat DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	115.7300	1	4			

D2622-120C

Step Extrusion

**

Ac 12.03.15

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA013	99.36	
75781	10.4	
77612	88.96	

D2734

Manufactured No

140 Each

83.0000

2

D2734

Step End Plate

**

12.03.19

Location	Loc Qty	Loc Code
WA	83	
76985	83	

D3560-041

Manufactured No

140 Each

0.0000

1

D3560-041

Arm Weldment

**

12.03.19

D3560-043

Manufactured No

140 Each

0.0000

1

D3560-043

Arm Weldment

**

12.03.19

B79076 = 4

B79077 = 4

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Parent Item Name: Step Assembly, LH

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D3562-041

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W5

Purchased

No

160

Each

1,097.000

32

128

MS20600-AD4W5

Blind Rivet

**

12.03.19

Location

Loc Qty

Loc Code

ST321

804

114382

173

117505

5

118384

226

120142

100

120594

300

WA018

293

111477

6

120570

287

128

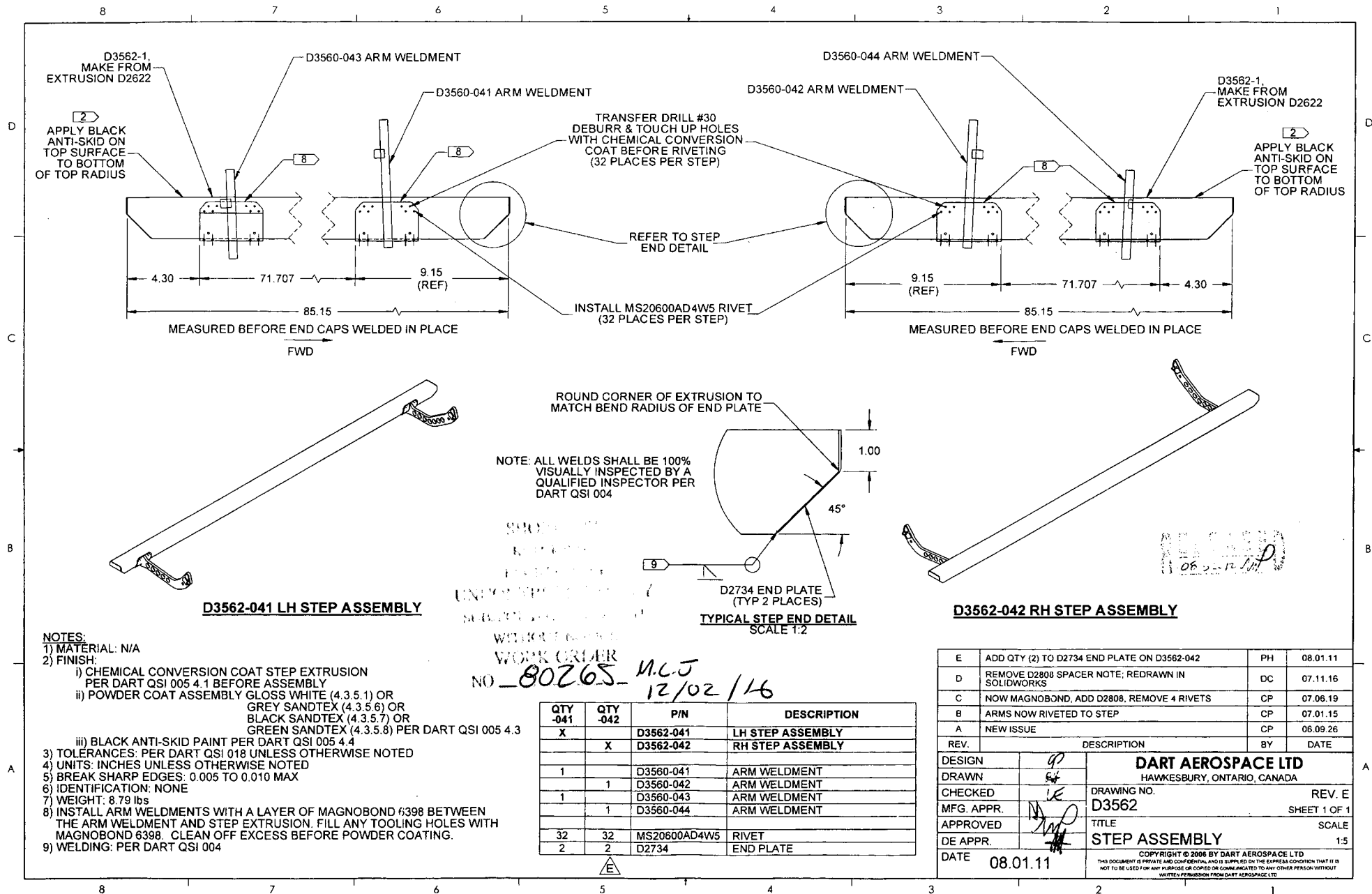
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